

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026231**Date Inspected:** 09-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

East Line

This QA randomly observed ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The joint being welded was buttering for the fit up of a 20mm plate insert at the "A" deck to close a man way deck penetration hole. Due to four (4) root gap locations measuring in excess of the maximum root gap tolerance of 7mm, this weld joint required buttering to bring it with in tolerance. This work was located at 8E-PP61.5-E5 and was performed in the overhead position from the inside of the "A" deck plate.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=117). Joint fit up has not been accepted by QC at this time.

This QA randomly observed ABF/JV qualified welder Fred Kaddu #2188 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110-R1. This was an (R1) repair of a Complete Joint Penetration (CJP) weld on a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E4-PP101-L#1, 3 and was performed in the flat position from the top of the "A" deck plate.

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During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=136).

Approximately-

14:00- this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the completed welds at this panel point E4-PP103-L#2, 4 location. Mr. Vonhoff recorded no rejectable indications at this time.

11E/12E

This QA randomly observed ABF/JV qualified welder Wai Kit Li #2953 and Hua Qiang Huang #2930 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1000-R. . The joint being welded was in the 3G vertical position at the side plate E1/E2 on the outside of the OBG 11E/12E.

Measurements are recorded in millimeters.

E1 (external)

Indication (Y=1340), Excavation (Y=1300, L=95, W=20, D=11)

Indication (Y=1960), Excavation (Y=1930, L=85, W=18, D=10)

Indication (Y=3850), Excavation (Y=3810, L=95, W=19, D=10)

Indication (Y=5000), Excavation (Y=4975, L=180, W=20, D=6)

E2 (external)

Indication (Y=3860), Excavation (Y=2820, L=85, W=16, D=11)

Indication (Y=5046), Excavation (Y=5015, L=210, W=20, D=11)

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as (A=124).

11:30 this QA observed QC Pat Swain performing Ultrasonic Testing (UT) of the Complete Joint Penetration (CJP) designated 11E/12E bottom plate "D2" from the internal side.

Testing is in progress and no reports QC have been filed at this time.

Ultrasonic Testing

This QA Inspector performed Ultrasonic Testing (UT) of approximately 100% of the weld repair area previously tested by QC Ultrasonic technicians. The joint is a Complete Joint Penetration (CJP) welded by Fred Kaddu #2188 utilizing the Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018HR4 electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. This work was located at E4-PP92-L#2 and was performed in the flat position from the top of the "A" deck plate.

This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

NO relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William
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Quality Assurance Inspector

Reviewed By:	Levell, Bill
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QA Reviewer
